Date: User: Customer This Issue Prsht Rev. First Issue **Previous Run** Written By Comment

Thursday, 28/05/2009 11:34:09 AM

Julie Dawson

## **Process Sheet**

: CU-DAR001 Dart Helicopters Services

Job Number : 48278 **Estimate Number** : 10503

P.O. Number

: 28/05/2009

: NC

: // : 46695

Type

S.O. No. :

: MACHINED PARTS

**Part Number** 

**Drawing Name** 

: D2745

**Drawing Number Project Number**  : D2745 REV B : N/A

: BUSHING

**Drawing Revision** 

Material

: 04/06/2009

: B

Qty:

100 Um: Each

Checked & Approved By

Update to turn in house NG

Est Rev:D 07-10-23 Removed tumbling

JLM Verified

**Due Date** 

By:EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M303R0750

303 Round Bar 0.750



Comment: Qty.:

0.1007 f(s)/Unit

Total: 10.0695 f(s)

303 ROUND .75"

Machine per Folio FA201 Material: AISI 303 SS

Batch: M/// 323

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2515

2-Deburr



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHIN



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

PACKAGING 1



PACKAGING RESOURCE #1



Location:



Comment: PACKAGING RESOURCE #1

Identify and Stock

## **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHAN	IGES					
DATE	STEP	PR	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							··			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es No	DQ,	<b>A</b> :	Date:	
		Dispositio	Disposition: Q			QA: N/C Closed:				
NCR:		·	WORK ORDI	ER NON-CONFOR	MANCE (N	CR)				W W.
DATE	STEP	Description of NC	Corrective Action Section			Verification			1 Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Secti		Chief Eng	QC Inspector
										;
				1						
		·								
	1 1		1		1	1			i	I

NOTE: Date & initial all entries

Date: User: Thursday, 28/05/2009 11:34:09 AM

Julie Dawson

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 48278

Part Number: D2745

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



mF 09-06-01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



		-				- •
1	-			pac	_	-
	21 T L	44	rne	nar	_	חו
_	ш.	$\sim$		Juc		

W/O:			WC	RK ORDER CHANG	iES				
DATE STEP		PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				7.0					
Part No				NCR: Yes No DQA: Date:					
	R		Disposition: QA						
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC	Initial	ion B		Verification	Approval	Approval	
		Section A	Chief Eng	Action Description Chief Eng	Date		C	Chief Eng	QC Inspecto
					,				
							:		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: USDIS	
Description: Bushing	Part Number: D2745	
Inspection Dwg: D2745 Rev: B	Page 1 of	1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

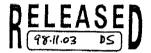
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.010	660				
0.400	+/-0.010	400				
0.060	+/-0.010 *	-062				
1.020	+/-0.010	(,020	/			
0.030 x 20°	+/-0.010	,030x2B				
Ø0.472	+/-0.010	0,472				
Ø0.375	+0.006/-0.001	182.				
Ø0.560	+/-0.010	0.358				
· Ø0.750	+/-0.010	8.746	/			
-						

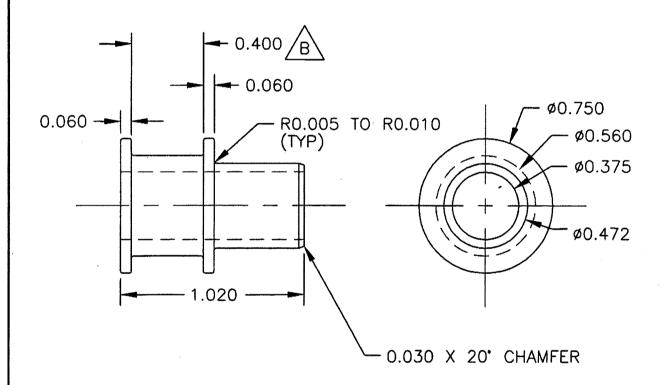
ħ.			
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 0905/25	Date: 09/05/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue	KJ/RF	
В	07.11.26	Tolerance for Ø0.375 revised	KJ/EC/DD	77
	<u> </u>		771	



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. REV. B D2745 SHEET 1 OF 1
DATE	<del></del>	TITLE SCALE
98.10.23		BUSHING 2:1
Α	98.04.16	NEW ISSUE
В	98.10.23	DIM 0.400 WAS 0.380





MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RADIUS ALL INSIDE EDGES 0.005 TO 0.010

SHOP COPY

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 RETURN TO

ALL DIMENSIONS ARE IN INCHES

**ENGINEERING** UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

Copyright 1998 by DART AEROSPACE USA, INC.